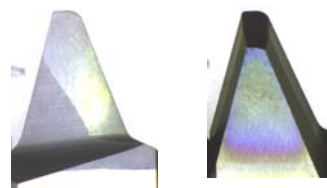
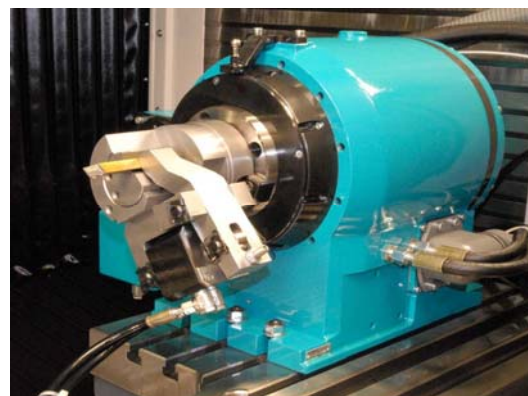















Gear Blade Oerlikon BxH 10.16 x 12.7

A12-350

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade and the cutting face. When inverting the operation on one of the sides, the complete profile can be preground with one side of the profile, preserving the opposite corner for finishing.



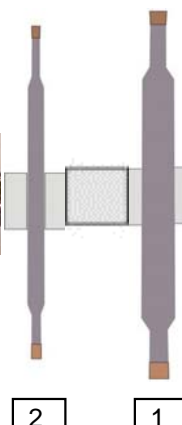
1. Cycletime for Resharpener

Workpiece:	RH inner blade Spir; 10.16 x 12.7 x 115 mm Material CARBIDE						
Operations							
Feed [mm/Min]	2000	40	40	70	70	40	70
Power [kW]		4	3	2	2	2	3
Cutting feed [m/s]		20	20	22	22	20	22
Used wheels							
Grinding time [s]	18	109	109	29	29	45	31
Total cycle time	6 Min 11						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø250 D64
2	14A1 Ø250 D64



3. Machine and Software Requirements

Machines:	5 axes CNC grinders : NORMA CFG	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:			
Responsible engineer:	OP. 18.11.09		

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